Work Order ID 86984 Friday, July 06, 2012 12:50:08 PM				*86	984*							Page 1
Item ID: Revision ID:	D412-630-032			Accept	*N900	1 040	100)* s	Setup	Start	*N	S1*
Item Name:	Pilot/Co-Pilot Step, R	H (Folding)			•					Stop	*N:	S2*
Start Date:	7/6/2012 Start	Qty: 2.00	*2*		Cust Item	ID:						
Required Date:	7/18/2012 Req'	d Qty: 2.00	*2*		Customer							
Reference:												
Approvals:	Process Plan:	14	Date:/2-074	Tooling:	I	Date:	_	R	Run	Start	*N	R1*
	QC:		Date:	_ SPC (Y/N):	I	Date:	 			Stop	*N	R2*
Sequence ID/ Work Center II	Opera Descr			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision N	br	i									
IIN D412-630	Rev M							,	^			
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Document Control		Photocopy 1	D412-630 bluefile & type	labels per PPP412-630-	-032 CHG003							(2)
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110	Small F	ab						\mathcal{C}			4	1-12/10/
Small Fab		Memo		0.00				.,,				/ /
Small Fab		Assemble as	s per IIN D412-630									
		****ensure A/R MS209	tension to retract step is 11 95C41 batch: 1/148	to 18 lbs before install	ling lockwire.***						,	
120	QC5- II	nspect part comp	leteness to step on W/O	0.00	n			2				
120			•		D			<u>د</u>				
QC		Memo	tamaiam ta matma at atem in 11) .6(00.0 N .6(18 18 18 18 18 18 18 18 18 18 18 18 18	5.12							-
Quality Control			tension to retract step is 11 ircraft in Eng. lab.	10 18 IOS ****								

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W/O:			V	VORK OR	DER CHANG	ES					
DATE	STEP	PRO	OCEDURE CI	HANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	:	PAR #:	Fault Ca	itegory:		_ NCF	l: Yes	10 DQ /	A:	Date:	
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DATE	STEP	Description of NC	1 66 2 2			ion B	Ö! 0	Verific	ation	Approval	Approval
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Work Order ID 86984 Friday, July 06, 2012 12:50:08 PM				*869	984*			and the state of t	Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date	7/6/2012	Step, RH (Folding) Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*	Accept	*N900 Cust Item I Customer:)∩* ^s	Setup Star	14.21
Approvals:		ın:	Date:	_ Tooling: _ SPC (Y/N):		nte:	F 	tun Star Stop	INKI
Sequence ID/ Work Center I 130 *120* Packaging Packaging	D	Operation Description Pick Kit Memo		Set Up/ Run Hours 0.00	Tool ID	Tool # Plan		Reject Qty	Reject Insp. Number Stamp
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*150 *150* Packaging Packaging		Packaging Memo Identify and Location: PPP Rev:	pack for shipping as per	0.00 0.00 PPP D412-630-032					12/0/18

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W/O:			V	VORK ORDER CHAN	IGES				*			
DATE	STEP	PR	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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		PAR #:	Fault Ca	tegory:	NCR: Ye	s No DO	QA:	Chief Eng / Prod Mgr QC Inspecto Date: Date: Approval Approval				
		esolution:	Disposit	ion: '	QA: N/C	Closed: _		Date: _				
NCR:			WORK OR	DER NON-CONFORI	MANCE (NO	R)						
DATE	STEP	Description of NC			ection B		ication	Approval	Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng	n Sigr Da	te Sec	tion C	Chief Eng	QC Inspector			
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Work Order ID 86984 Friday, July 06, 2012 12:50:09 PM				*869	984*							Page 3
Item ID: Revision ID:	D412-630-0	32		Accept	*N900	040	100)*	Setup	Start	*N	S1*
Item Name:	Pilot/Co-Pilot	t Step, RH (Folding)			•				, -	Stop	*N	S2*
Start Date:	7/6/2012	Start Qty: 2.00	*2*		Cust Item I	D:						
Required Date:	7/18/2012	Req'd Qty: 2.00	*2*		Customer:							
Reference:			•									
Approvals:	Process Pla	an:	Date:	Tooling:	D:	ate:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Date:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	-	Reject Number	Insp. Stamp
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Quality Control

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Dart Aerospace Ltd

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W/O:			V	VORK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:	NCR	: Yes N	o DQA	A:	_ Date: _	
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DATE	STEP Description of NC Section A		Corrective Action Initial Action Descri Chief Eng Chief Eng		Section B otion Sign Date		Verification Section C		Approval Chief Eng	Approval QC Inspecto

Picklist Print

Friday, July 06, 2012 12:50:13 PM

Work Order ID: 86984

86984

Parent Item:

D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/6/2012

Required Date: 7/18/2012

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV. A 05.11.21 **NEW ISSUE**

EC IPP REV. B 05.12.19 EC updated pick list

IPP REV.C 07.11.12 ecn 1019, nochg EC verifiedby:DD IPP Rev:D 10.05.28 added route seq DD verf:EC

IPP Rev: E 11.06.01

removed atv1 an310-4 EC verified by: DD

1	choved quy rans r	0-4 LC VCIII	cu by. Di	,									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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W/O:			WC	RK ORDER CHANG	ES			,				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC inspector				
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							(A) (A)	1447.				
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)							
DATE	STEP	Description of NC		Corrective Action Section		Verification	on Approval	Approval				
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Friday, July 06, 2012 12:50:13 PM

Work Order ID: 86984

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

86984

D412-630-032

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

AN3C5A

Parent Item:

Purchased

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Purchased

No

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117343		13		
117764		7		
117872		2		
119749		23		ARABIN S
120423		28		
121255		469		
121444		34		
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AN44-C12

Location ST362 120139

Loc Oty 18 18 130 Each

Loc Code

42.0000

Loc Code

AN4C15

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Dart Aerospace Ltd

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W/O:			WC	ORK ORDER CHANGE	S				-
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Friday, July 06, 2012 12:50:13 PM

Work Order ID: 86984		*8	6984*							
Parent Item: D412-630-032			412-630-0	32*						
Parent Item Name: Pilot/Co-Pilot Step	, RH (Folding)	• •				St	art Date: 7/6/201	2 Requ	ired Date: 7/18	3/2012
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W/O:			W	ORK ORDER CHAN	GES			``	
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Friday, July 06, 2012 12:50:13 PM

	Work Order ID: 86984			6984*						
-	Parent Item: D412-630-032 Parent Item Name: Pilot/Co-Pilot St	ep, RH (Folding)	*D	412-630-0	132*			art Date: tart Qty:		Required Date: 7/18/2012 Required Qty: 2.00
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RM.	racket Assembly			<u>Location</u> ST199 75182	<u>Lo</u>	2 Qty 3 3	Loc Code			36032 Sp 601

Dart Ae	rospace	e Ltd							, •
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Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date:	
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign &		cation on C	Approval Chief Eng	Approval QC inspector
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Friday, July 06, 2012 12:50:14 PM

Work Order ID: 86984

Parent Item:

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

86984

D412-630-032

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

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Purchased

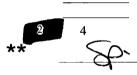
Purchased

No

Location	Le	oc Qty
FG		72
103691		72
ST301		1056
118077		2
118614		12
118686		30
119758		20
121255		103
121708		889
	130	Each

106.0000

Loc Code





	ST309	
		111041
		120124
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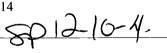
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W/O:			V	VORK ORDER CHANG	ES		· · · · · · · · · · · · · · · · · · ·		•
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Friday, July 06, 2012 12:50:14 PM

Work Order ID: 86984

86984

Parent Item:

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

D412-630-032

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

NAS1515H5

Purchased

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Location	Loc Qty	Loc Code			
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GA	36				
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121652	100				
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D3455-1

Manufactured

D3455-1

Spacer

Location	Loc Oty	Loc Code
ST044	35	
82025	35	
-	110 Each	3.0000

D3443-041

Manufactured

Strut Weldment Assembly

Location Loc Code Loc Qty ST199 3 78188 1 2 78948 [110] Each 0.0000

D3463-042

Manufactured

Step Weldment Assembly

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRC	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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ني محمد .									
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
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Friday, July 06, 2012 12:50:14 PM

Work Order ID: 86984 *86984* D412-630-032 *D412-630-032* Parent Item: **Required Date:** 7/18/2012 Parent Item Name: Pilot/Co-Pilot Step, RH (Folding) Start Date: 7/6/2012 Required Qty: 2.00 Start Qty: 2.00 D3443-9 Manufactured No 110 Each 18.0000 2 4 ** *D3443-9* Location Loc Qty Loc Code ST044 18 78189 1 7 82161 10 83465 110 40.0000 AN4C14 No Each Purchased ** *AN4C14* BOLT Location Loc Qty Loc Code ST357 40 117688 2 120141 38 MS24665-229 Purchased No 130 Each 245.0000 Location Loc Qty Loc Code ST309 245 98 111041 118234 147 MS24665-227 (110 Each 106.0000 Purchased No *MS24665-227* COTTER PIN Loc Oty Loc Code Location ST309 106 111041 37 120124 69

Dart Ae	rospace	e Ltd							
W/O:			W	ORK ORDER CHANGE	S	-			ie .
DATE STEP		PRO	ROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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		Description of NC	Corrective Action Sec		Section B		cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ection C	Chief Eng	QC Inspector
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Friday, July 06, 2012 12:50:14 PM

86984 Work Order ID: 86984 Parent Item: D412-630-032 *D412-630-032* Parent Item Name: Pilot/Co-Pilot Step, RH (Folding) Start Date: 7/6/2012 Required Date: 7/18/2012 Required Qty: 2.00 Start Qty: 2.00 110 AN4CH3 Purchased No Each 24.0000 ** *AN4CH3* SS Bolt Location Loc Qty Loc Code ST357 24 117616 1 120139 23 [110] 15.0000 D3465-1 No Each Manufactured ** *D3465-1* Washer Location Loc Qty Loc Code ST045 15 73449 1 78197 14 AN310-4 130 98.0000 No Each Purchased m/22800 8p. ** Location Loc Code Loc Qty ST344 98 2 121349 121827 96 D3443-043 Manufactured No 110 Each 2.0000 B87159 2x SD 12-10-4. ** Strut Weldment Assembly Location Loc Qty Loc Code ST198A -8 ST199 10 78954 2

Dart Aerospace Ltd

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W/O:			WORK ORDER CHANGES						
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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D.4.T.E		Description of NC		Corrective Action Section B Verification Approva	Annroval	Approval			
DATE	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	Section C	Chief Eng	QC Inspector

Friday, July 06, 2012 12:50:14 PM

Work Order ID: 86984

86984

Parent Item:

D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

D3454-7

Manufactured

Each 18.0000

**

D3454-7

Bushing

Location

ST044

Loc Qty 18 Loc Code

Loc Code

AN310-7

No Purchased

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SP 12-10-4.

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Dart Ae	rospace	Ltd							ć c
W/O:			W	ORK ORDER CHANGI	ES				•
DATE	STEP	PROCEDURE CHANGE			Ву	Date	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cat	egory:	NCR: Ye	s No D	QA:	Date: _	
	Re	esolution:	Dispositi	on: '	QA: N/C	Closed: _		Date: _	
NCR:		\	WORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	0755	Description of NC	Corrective Action Section B			Veri	fication	Approval	Approval
DATE	STEP	Section A			on Sign & Date		N& Section C		QC inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC inspector		
		t ⊀.								

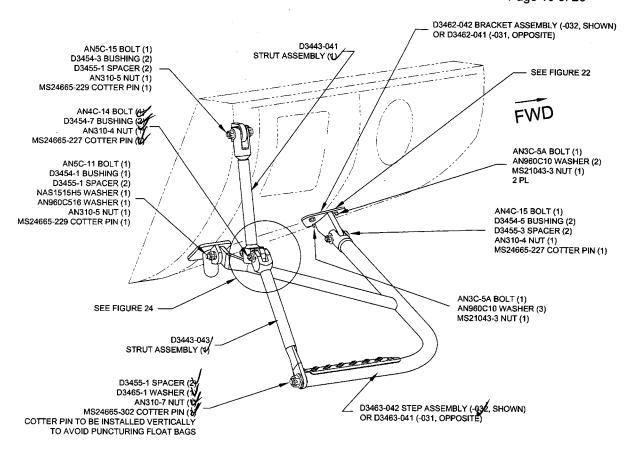


FIGURE 23 - Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

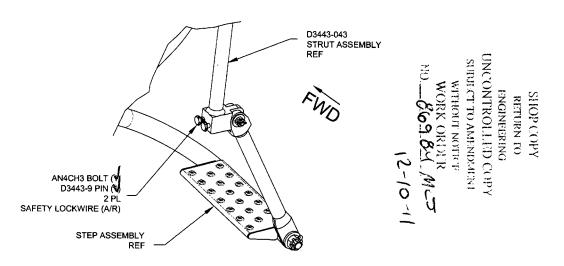


FIGURE 24 - Detail Safety Wiring, D412-630-032 RH,Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

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> M Revision:

Date: 08.12.12 3

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Qty -031	Øty -0,32	Part Number	Description
Х		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	Х	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	- D3443-041	STRUT ASSEMBLY
1	1-1-	D3443-043	STRUT ASSEMBLY
2	2	_ D3443-9	PIN
1	11	D3454-1 <u></u>	BUSHING
2	<u>~2</u>	D3454-3 /	BUSHING
2	72	D3454-5	BUSHING
_2	2	D3454-7	_BUSHING
6	16	D3455-1	SPACER (2)
2	72	D3455-3/	SPACER
1		_D3462-041	BRACKET ASSEMBLY
	11	D3462-042 /	BRACKET ASSEMBLY
4		D3463-041	STEP ASSEMBLY
	-1-	D3463-042	STEP ASSEMBLY
1		D3465-1	WASHER
2	2	AN310-4	NUT (-1)
2	2	AN310-5	NUT

NUT

BOLT

BOLT

BOLT

BOLT

BOLT

BOLT

NUT

WASHER

WASHER

WASHER

COTTER PIN COTTER PIN

COTTER PIN (-1)

* EYEBOLT

AN310-7 AN3C-5A

AN4C14

AN4C15

AN4CH3

AN5C11

AN5C15

AN960C10

AN960C516

MS21043-3

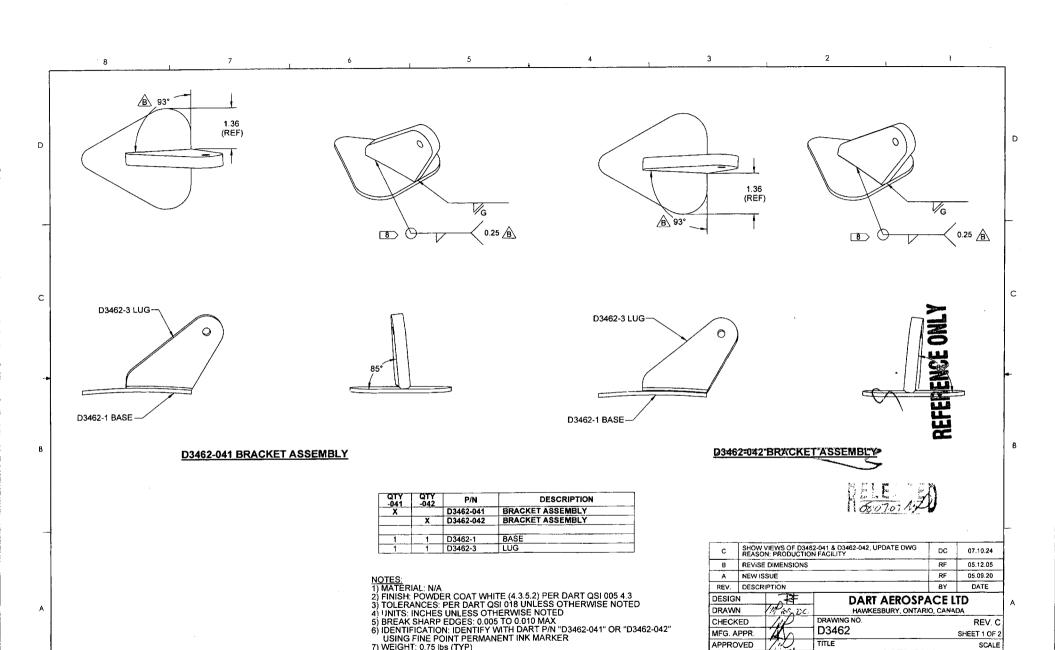
MS24665-227

MS24665-229

MS24665=302 NAS1515H5-

AN44-C12

^{*} USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034TM HELI-ACCESS-STEP



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7) WEIGHT: 0.75 lbs (TYP) 8) WELDING: PER DART QSI 004

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MFG. APPR.

APPROVED

07.10.24

DE APPR.

DATE

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D3462

BRACKET ASSEMBLY

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TITLE

SHEET 1 OF 2

SCALE